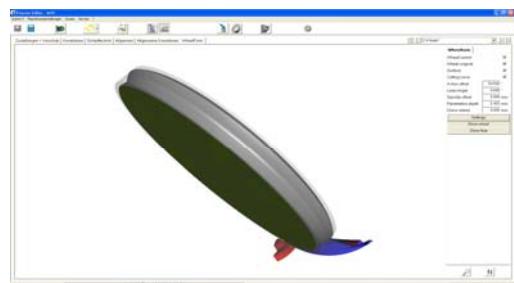


## Piloted Counterbore M10

A06-330

The flute and back of the counterbore is ground in one pass with a corresponding formwheel. The form is automatically generated using the Quinto-integrated wheelformcalculation. The pilotoperation grinds 0.5 mm overmeasure in deepcreep spiralgrinding and finishes oscillation in finishing passes of 0.005 mm.



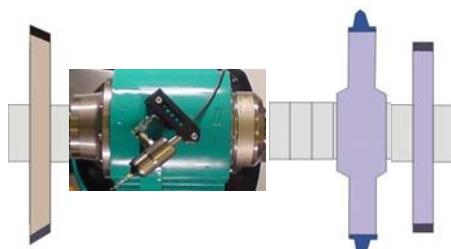
### 1. Cycletime for Production

Workpiece: Ø 18 mm, Z 3, Length 36 mm, Helix 28° Material HSS					
Operations	Probe	Flute 1	End 1	cyl. Pilot	Load
Feed [mm/Min]	2000	80	80	100	9000
Power [kW]		6	1	1	1
Cutting feed [m/s]		32	32	32	
Used wheels		1	2	3	
Grinding time [s]	12	124	44	83	23
Total cycle time	4 Min 45				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	DXF Ø150 B126
2	1V1 Ø150 B126
3	1A1 Ø150 B126



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1 3

### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR 26  
 Control: Fanuc 31i  
 Accessories: Robot, Dressing unit  
 Responsible engineer: OP. 14.4.11

Coolant: Synthetic Oil, pressure 16 bar  
 Software: Quinto 5

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